

Work Order ID 70999

Monday, June 20, 2011 4:00:16 PM

Page 1

Item ID: D3025-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Beam

Start Date: 6/20/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 6-20-20

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3025

B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B11-6-21

2024.080

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-6-21

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8 w/dec 22

(47)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70999

Page 2

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Item ID: D3025-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Beam

Start Date: 6/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.00 0.00		SB 11/06/22		7			
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				7		BL 11-6-23.	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				7	6	11/06/22	

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Item ID: D3025-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Beam

Start Date: 6/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: ST 177

0.00



Packaging

Memo

0.00

Packaging

fb(1)11/06/24

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/24ME11-06-24

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, June 20, 2011 4:00:22 PM

Page 1

Work Order ID: 70999

Parent Item: D3025-1

Parent Item Name: Beam



Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C01.10.26 Added Bending as per Drawing. SM
11.05.16 MAT'L THICKNESS CHG DD VERF:EC IPP REV:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.080		Purchased	No			100	sf	110.1000	0.75	3.157895	5.5		
--------------	--	-----------	----	--	--	-----	----	----------	------	----------	-----	--	--



Blt-6-21

2024-T3 .080 sheet

Location

Loc Qty

Loc Code

MAT022

110.1

105411

6

109424

4

110347

0.5

110908

3

112331

3

113796

7

114025

17.2

116604

5.8

117392

63.6

117392

7

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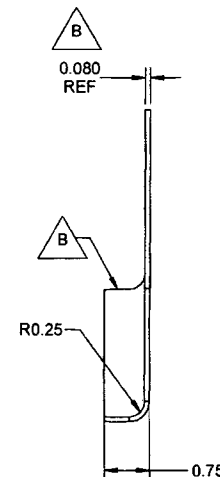
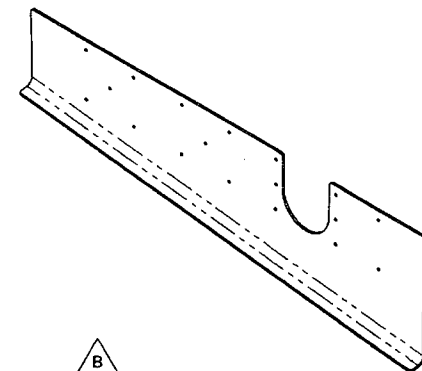
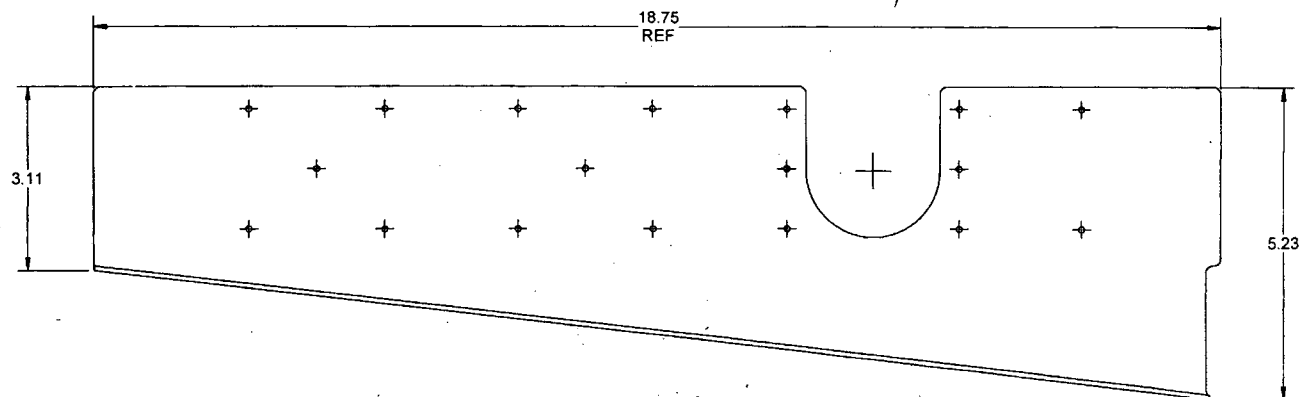
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70929
11-0620



D3025-1 BEAM

RELEASED
2011-05-18

NOTES:

- 1) MATERIAL: MAKE FROM D3025-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs

B	5.78 WAS 6.584 (ZN B2-2); 0.080 WAS 0.050 (ZN C2-1 & B1-2); DIMENSIONS CHANGED TO 2 DEC PLACES; REVERSE BEND	RF	11.05.11
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3025	REV. B
TITLE BEAM	SCALE NTS
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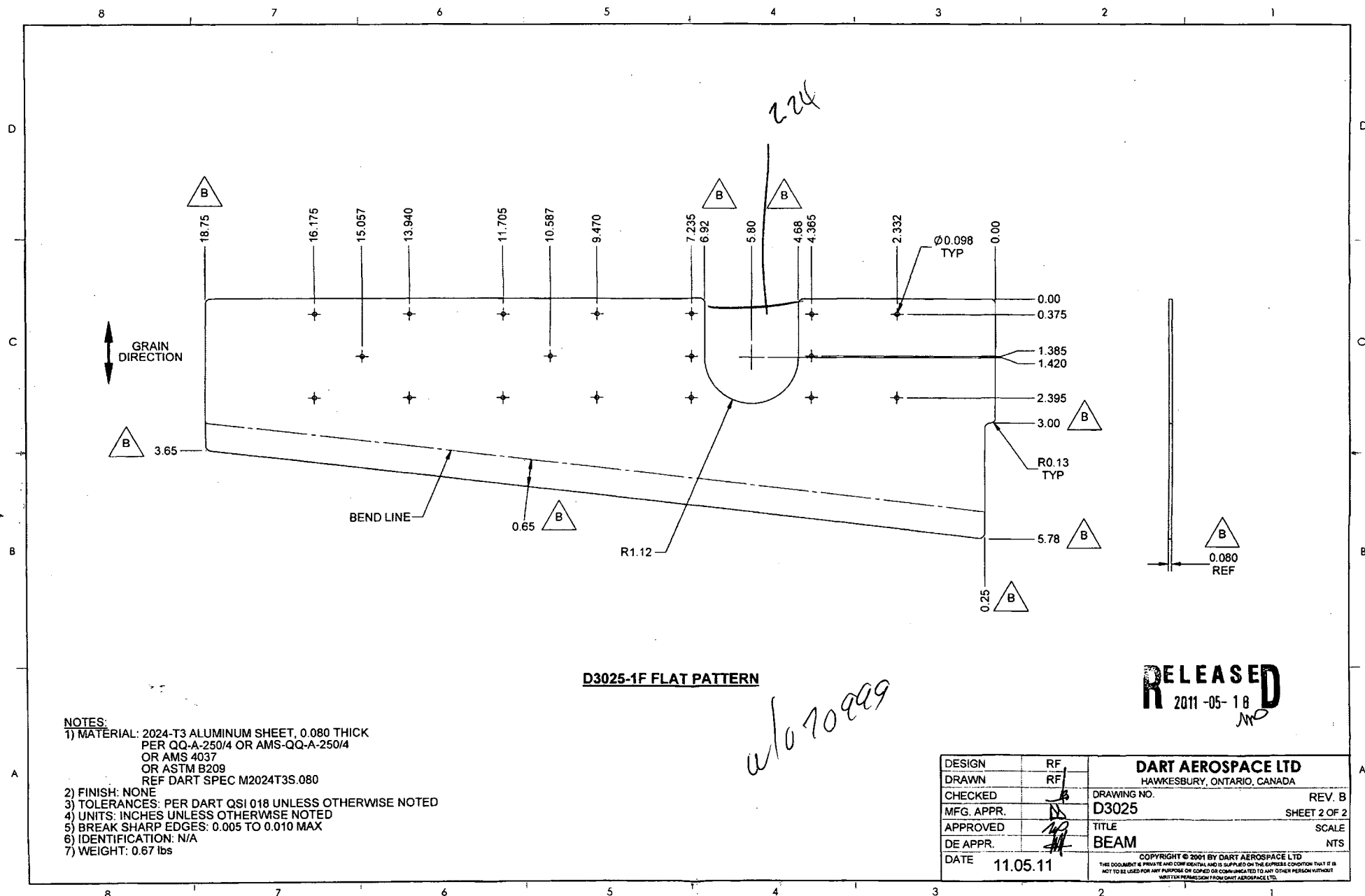
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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC M2024T3S.080
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

RELEASED
2011-05-18
MO

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3025	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BEAM	NTS
DATE	11.05.11	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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